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## IMPROVEMENT OF CONDITIONS FOR MESHING SPIRAL BEVEL GEARS

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(NASA-TM-77867) IMPROVEMENT OF CONDITIONS  
FOR MESHING SPIRAL BEVEL GEARS (National  
Aeronautics and Space Administration) 24 p  
HC A02/MF A01

N85-29294

CSCL 131

Unclass

G3/37 21568

Translation of Uluchsheniye Usloviy Zatsepleniya Konicheskikh  
Zubchatykh Koles s Normal'no Ponizhayushchimisya Dugovymi  
Zubstami, (Narezannykh s Korrekturoy Nastroyki Zubchreznogo Stanka)  
Teoriya Mashin i Mekhanizmov [Proceedings of Machine and  
Mechanics Theory], No. 98-99, Nauka Press, Moscow, 1964, pp. 87-103



1. Report No. NASA TM-77867	2. Government Accession No.	3. Recipient's Catalog No.	
4. Title and Subtitle IMPROVEMENT OF CONDITIONS FOR MESHING SPIRAL BEVEL GEARS		5. Report Date June 1985	
		6. Performing Organization Code	
7. Author(s) F. I. Litvin and Go Kay		8. Performing Organization Report No.	
		10. Work Unit No.	
9. Performing Organization Name and Address The Corporate Word, Inc. 1102 Arrott Bldg. Pittsburgh, PA 15222		11. Contract or Grant No. NASW-4006	
		13. Type of Report and Period Covered Translation	
12. Sponsoring Agency Name and Address National Aeronautics and Space Administration Washington, DC 20546		14. Sponsoring Agency Code	
15. Supplementary Notes Translation of Uluchsheniye Usloviy Zatsepleniya Konicheskikh Zubchatykh Koles s Normal'no Ponizhayushchimisya Dugovymi Zubstami / Narezannykh s Korrekturoy Nastroyki Zuboreznogo Stanka / Teoriya Mashin i Mekhanizmov [Proceedings of Machine and Mechanics Theory], No. 98-99, Nauka Press, Moscow, 1964, pp. 87-103			
16. Abstract This article analyzes the effect of axial pinion displacement on gear meshing conditions during cutting and correction of the rolling chain gear ratio. The so-called inverse problem-solving method is used.			
17. Key Words (Selected by Author(s))		18. Distribution Statement  Unlimited	
19. Security Classif. (of this report) Unclassified	20. Security Classif. (of this page) Unclassified	21. No. of Pages 24	22. Price

## IMPROVEMENT OF CONDITIONS FOR MESHING SPIRAL BEVEL GEARS

F.I. Litvin, Kai Go

In the previous article [1], the authors proved /87\*  
analytically that meshing spiral bevel gears cut without  
correcting the set-up of the gear-cutting machine has the  
following deficiencies:

- the operating line on the tooth's surface, which defines the position of the bearing pattern, is diagonal, and the gear ratio is variable.

E. Waldgaber [2] showed that eliminating these deficiencies requires correcting the adjustment of a pinion to be cut and the kinematic set-up of the gear-cutting machine.

V. N. Kedrinskiy and K. M. Pismanik [3] developed several methods for correcting machine set-up, among which the most commonly used are 1) changing the axial displacement of the change gear and the gear ratio of the machine's rolling chain and 2) changing the axial and hypoid displacements of the gear and the gear ratio of the rolling chain. They also proposed approximation equations for determining these corrections.

This article analyzes the effect of axial pinion displacement on gear meshing conditions during cutting and correction of the rolling chain gear ratio. The so-called inverse problem-solving method, presented in the authors' work [3] and in F. L. Litvin's work [5], is used.

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\*Numbers in the margin indicate pagination of the foreign text.



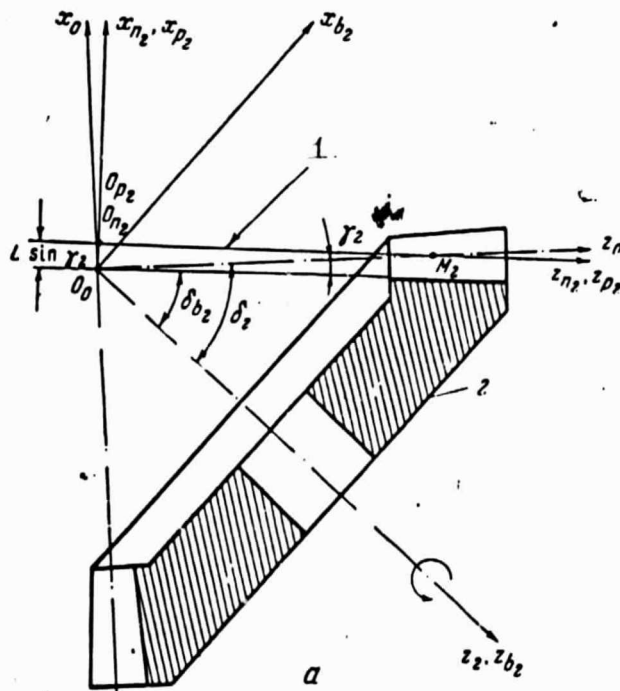


introduced, because cutting pinion 1 and gear 2 using different generating surfaces (cf. figures 1 and 2) is considered separately.

The coordinate system  $x_{ni}, y_{ni}, z_{ni}$  is an auxiliary fixed coordinate system in which the rotation of crown wheel  $p_i$  is given. When teeth are being cut, crown wheel  $p_i$  rotates around axis  $x_{ni}$ . The symbol  $\psi_i$  is the current angle of rotation. The plane  $x_{ni} = 0$ , the locating plane, is parallel to the plane tangent to the root cone of the gear being cut. The forming radius of the cutting head  $r_i$  and angle  $\beta_i$  between the tangent to the longitudinal line of the tooth at the midpoint  $M_i$  and axis  $z_{pi}$  are set in the locating plane (figures 1, b, 2, b). Cutting head adjustment parameters  $q_i$  and  $b_i$  are determined from functions (3.7), (3.8), and (3.9), introduced below. When

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a)



b)

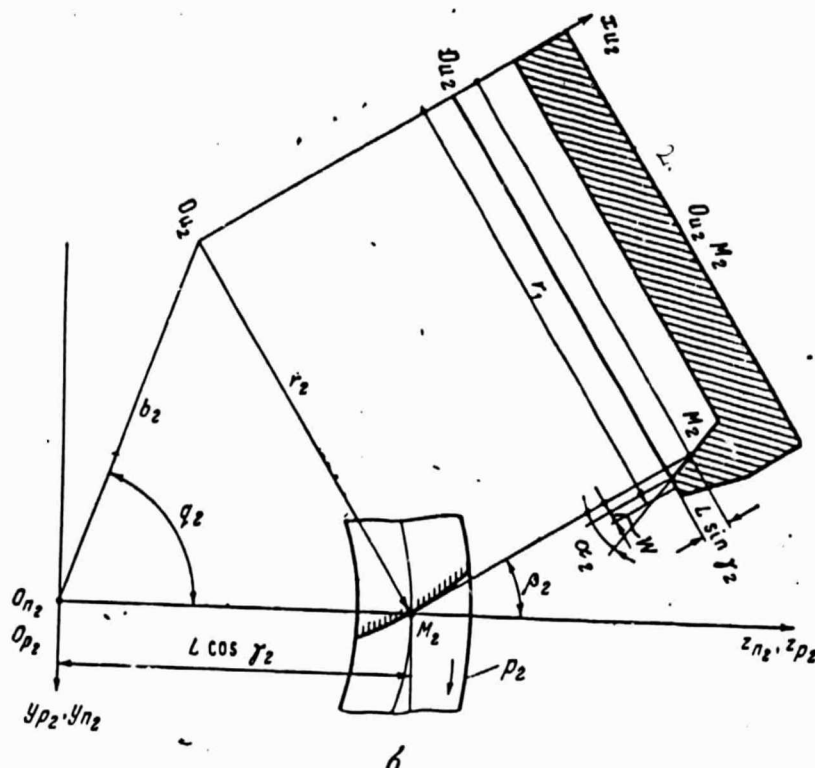


Figure 2. Coordinate system corresponding to cutting a wheel. 1 - Locating plane; 2 - Section  $O_{u2} M_2$

the cutting head turns around axis  $O_{ui}$  (cf. figure 1, b, 2, b), a bevel surface results, which is also crown. /90

When a pinion is being cut, it assumes axial shift  $O_0 O'_0$  (cf. figure 1), where  $O_0$  is the point of intersection of the axes of the pinion and the gear during meshing in gearing, and  $O'_0$  is the point of intersection of axis  $z_1$  of pinion rotation during cutting with rotation axis  $x_{ni}$  for crown wheel  $p_i$ . The gear is cut without axial shift (cf. figure 2), and  $O_0$  is both the point of intersection of pinion and gear axes when they mesh and the point of intersection of axis  $z_2$  of the gear when it is cut and axis of rotation  $x_{ni}$  of crown wheel  $p_2$ .

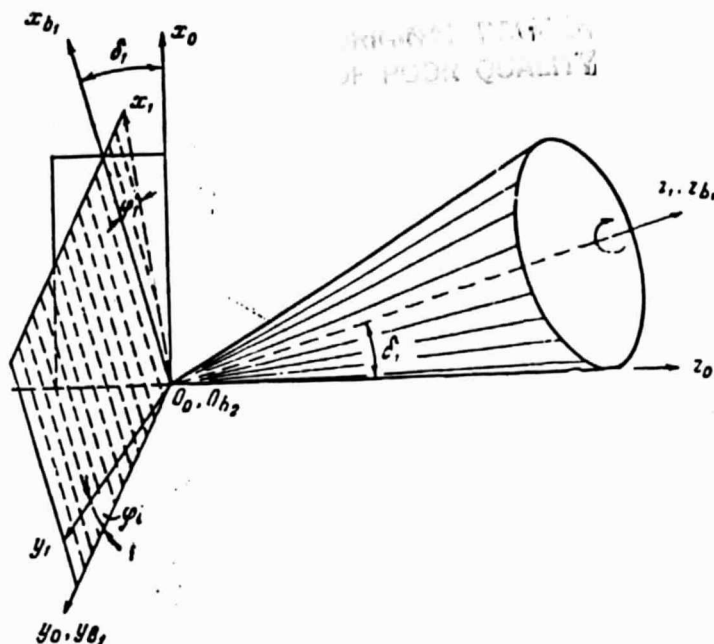


Figure 3. Solving equations for the relationship between coordinate systems  $x_{bi}$ ,  $y_{bi}$ ,  $z_{bi}$  and  $x_0$ ,  $y_0$ ,  $z_0$ .

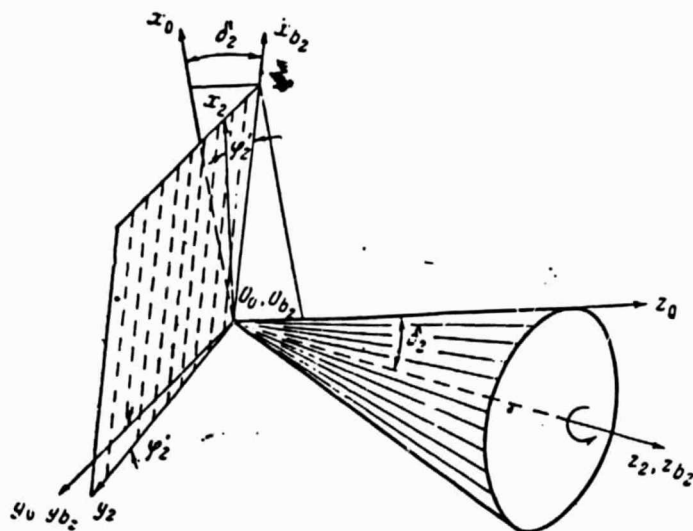


Figure 4. Solving equations for the relationship between coordinate systems  $x_{b2}$ ,  $y_{b2}$ ,  $z_{b2}$  and  $x_0$ ,  $y_0$ ,  $z_0$ .

The fixed coordinate system  $x_0$ ,  $y_0$ ,  $z_0$  considers the meshing of the pinion and the wheel. Axis  $0_0 z_0$  coincides with the overall generatrix of the initial bevel of the pinion and gear, and  $0_0$  is, as already mentioned, the point of intersection of their axes of rotation. System  $x_0$ ,  $y_0$ ,  $z_0$  is turned by angle  $\gamma_1$  of the tooth edge around  $y_{n1}$ , and coordinate origin  $0_0$  relative to  $0_{n1}$  is shifted by the value:

$$x_{n1} = L \sin \gamma_1; y_{n1} = 0; z_{n1} = -\Delta L_1; \quad (\text{cf. figure 1})$$

$$x_{n2} = -L \sin \gamma_2; y_{n2} = z_{n2} = 0. \quad (\text{cf. figure 2})$$

Here  $L = O_0M_1 = O_0M_2$  is the midpoint of the generatrix of the initial cone.

The gear being cut,  $i$ , has a coordinate system  $x_i, y_i, z_i$  ( $i = 1, 2$ ). Pinion and gear, when meshing, rotate respectively around axes  $z_{b1}$  and  $z_{b2}$ , which coincide with axes  $z_1$  and  $z_2$ . Auxiliary fixed coordinate system  $x_{bi}, y_{bi}, z_{bi}$ , presented in figures 3 and 4, can also be used to illustrate the transition to this system from system  $x_0, y_0, z_0$ .

## 2. Gear Tooth Surface Equations

When a gear is being cut, axis  $O_0z_0$  is the instantaneous rotation axis in relative motion. Determining the line of contact of the crown and cut surfaces requires that the normal to the surfaces at points on the line of contact must intersect axis  $O_0z_0$ .

In our article [1], tooth surface  $\Sigma_2$  was determined with the following equations:

$$\begin{aligned} x_2 &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) a_1^{(s)} + u_2 \sin \alpha_2 \sin \vartheta_2 b_1^{(s)} + \\ &\quad + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) c_1^{(s)}; \\ y_2 &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) a_2^{(s)} + u_2 \sin \alpha_2 \sin \vartheta_2 b_2^{(s)} + \\ &\quad + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) c_2^{(s)}; \\ z_2 &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) a_3^{(s)} + u_2 \sin \alpha_2 \sin \vartheta_2 b_3^{(s)} + \\ &\quad + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) c_3^{(s)}; \\ [u_2 - (r_2 \operatorname{ctg} \alpha_2 + L \sin \gamma_2) \cos \alpha_2] \sin (\vartheta_2 - q_2 + \psi_2) + \\ &\quad + b_2 [\cos \alpha_2 \operatorname{tg} \gamma_2 \sin \vartheta_2 - \sin \alpha_2 \sin (q_2 - \psi_2)] = 0. \end{aligned} \quad (2.1)$$

The projection of the vector of the normal to surface  $\Sigma_2$  was expressed as

$$\begin{aligned} e_x &= \sin \alpha_2 a_1^{(s)} + \cos \alpha_2 \sin \vartheta_2 b_1^{(s)} + \cos \alpha_2 \cos \vartheta_2 c_1^{(s)}; \\ e_y &= \sin \alpha_2 a_2^{(s)} + \cos \alpha_2 \sin \vartheta_2 b_2^{(s)} + \cos \alpha_2 \cos \vartheta_2 c_2^{(s)}; \\ e_z &= \sin \alpha_2 a_3^{(s)} + \cos \alpha_2 \sin \vartheta_2 b_3^{(s)} + \cos \alpha_2 \cos \vartheta_2 c_3^{(s)}. \end{aligned} \quad (2.2)$$

In equations (2.1) and (2.2):

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$$\begin{aligned}
 a_1^{(n)} &= \cos \varphi_2 \cos \delta_{b_1}; \\
 a_2^{(n)} &= -\sin \varphi_2 \cos \delta_{b_1}; \\
 a_3^{(n)} &= -\sin \delta_{b_1}; \\
 b_1^{(n)} &= \sin \varphi_2 \cos (q_2 - \psi_2) + \cos \varphi_2 \sin \delta_{b_1} \sin (q_2 - \psi_2); \\
 b_2^{(n)} &= \cos \varphi_2 \cos (q_2 - \psi_2) - \sin \varphi_2 \sin \delta_{b_1} \sin (q_2 - \psi_2); \\
 b_3^{(n)} &= \cos \delta_{b_1} \sin (q_2 - \psi_2); \\
 c_1^{(n)} &= -\sin \varphi_2 \sin (q_2 - \psi_2) + \cos \varphi_2 \sin \delta_{b_1} \cos (q_2 - \psi_2); \\
 c_2^{(n)} &= -\cos \varphi_2 \sin (q_2 - \psi_2) - \sin \varphi_2 \sin \delta_{b_1} \cos (q_2 - \psi_2); \\
 c_3^{(n)} &= \cos \delta_{b_1} \cos (q_2 - \psi_2).
 \end{aligned}$$

Crown surface  $\Sigma_{p2}$  and the projection of the vector of the normal to the same surface in system  $x_0, y_0, z_0$  were expressed by the equations:

$$\begin{aligned}
 x_0^{(p_2)} &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) \cos \gamma_2 - \\
 &- u_2 \sin \alpha_2 \sin \gamma_2 \cos (\theta_2 - q_2 + \psi_2) - b_2 \sin \gamma_2 \cos (q_2 - \psi_2);
 \end{aligned} \quad (2.3)$$

$$\begin{aligned}
 y_0^{(p_2)} &= u_2 \sin \alpha_2 \sin (\theta_2 - q_2 + \psi_2) - b_2 \sin (q_2 - \psi_2); \\
 z_0^{(p_2)} &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) \sin \gamma_2 + \\
 &+ u_2 \sin \alpha_2 \cos \gamma_2 \cos (\theta_2 - q_2 + \psi_2) + b_2 \cos \gamma_2 \cos q_2; \\
 e_{x_0}^{(p_2)} &= \sin \alpha_2 \cos \gamma_2 - \cos \alpha_2 \sin \gamma_2 \cos (\theta_2 - q_2 + \psi_2); \\
 e_{y_0}^{(p_2)} &= \cos \alpha_2 \sin (\theta_2 - q_2 + \psi_2); \\
 e_{z_0}^{(p_2)} &= \sin \alpha_2 \sin \gamma_2 + \cos \alpha_2 \cos \gamma_2 \cos (\theta_2 - q_2 + \psi_2).
 \end{aligned} \quad (2.4)$$

In equations (2.1), (2.2), (2.3), and (2.4):  $u_2$  and  $\theta_2$  are independent parameters of the crown surface;  $\alpha_2$  is the cutter profile angle;  $r_2$  is the forming radius of the cutting head;  $q_2$  and  $b_2$  are head adjustment parameters;  $\delta_{b2}$  is the gear's internal cone;  $\gamma_2$  is the angle of the dedendum part of the tooth;  $\tau_2$  and  $\phi_2$  are the rotation angles for the crown wheel and the wheel being cut. Then

$$\varphi_2 = \psi_2 \frac{\cos \gamma_2}{\sin (\delta_{b_1} + \gamma_2)}.$$

When a pinion wheel is being cut,  $o_0z_0$  is the instantaneous rotation axis in relative motion. Using the conclusion presented in [3], we can represent pinion tooth surface  $\Sigma_1$  with the following equation:

$$\begin{aligned} z_1 = & (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) a_2^{(1)} + u_1 \sin \alpha_1 \sin \vartheta_1 b_2^{(1)} + \\ & + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1) c_2^{(1)} + |\Delta L_1| \cos \delta_{b1}; \\ | - u_1 + & (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1 - |\Delta L_1| \operatorname{tg} \delta_{b1}) \cos \alpha_1 | \sin (\vartheta_1 - q_1 + \psi_1) + \\ & + b_1 \sin \alpha_1 \sin (q_1 - \psi_1) + b_1 \cos \alpha_1 \sin \vartheta_1 \operatorname{tg} \gamma_1' = 0, \end{aligned} \quad /93$$

$$\begin{aligned} z_1 = & (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) a_2^{(1)} + u_1 \sin \alpha_1 \sin \vartheta_1 b_2^{(1)} + \\ & + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1) c_2^{(1)} + |\Delta L_1| \cos \delta_{b1}; \\ | - u_1 + & (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1 - |\Delta L_1| \operatorname{tg} \delta_{b1}) \cos \alpha_1 | \sin (\vartheta_1 - q_1 + \psi_1) + \\ & + b_1 \sin \alpha_1 \sin (q_1 - \psi_1) + b_1 \cos \alpha_1 \sin \vartheta_1 \operatorname{tg} \gamma_1' = 0, \end{aligned} \quad (2.5)$$

where  $\gamma_1'$  is the angle between instantaneous axis  $0'M_1$  and the generatrix of the inner pinion cone.

The projection of the unit vector of the normal to surface  $\Sigma_1$  is determined with the equations:

$$\begin{aligned} e_{x_1} = & \sin \alpha_1 a_1^{(1)} + \cos \alpha_1 \sin \vartheta_1 b_1^{(1)} + \cos \alpha_1 \cos \vartheta_1 c_1^{(1)}; \\ e_{y_1} = & \sin \alpha_1 a_2^{(1)} + \cos \alpha_1 \sin \vartheta_1 b_2^{(1)} + \cos \alpha_1 \cos \vartheta_1 c_2^{(1)}; \\ e_{z_1} = & \sin \alpha_1 a_3^{(1)} + \cos \alpha_1 \sin \vartheta_1 b_3^{(1)} + \cos \alpha_1 \cos \vartheta_1 c_3^{(1)}. \end{aligned} \quad (2.6)$$

In equations (2.5) and (2.6)

$$\begin{aligned} a_1^{(1)} = & \cos \varphi_1 \cos \delta_{b1}; \\ a_2^{(1)} = & \sin \varphi_1 \cos \delta_{b1}; \\ a_3^{(1)} = & \sin \delta_{b1}; \\ b_1^{(1)} = & -\sin \varphi_1 \cos (q_1 - \psi_1) - \cos \varphi_1 \sin \delta_{b1} \sin (q_1 - \psi_1); \\ b_2^{(1)} = & \cos \varphi_1 \cos (q_1 - \psi_1) - \sin \varphi_1 \sin \delta_{b1} \sin (q_1 - \psi_1); \\ b_3^{(1)} = & \cos \delta_{b1} \sin (q_1 - \psi_1); \\ c_1^{(1)} = & \sin \varphi_1 \sin (q_1 - \psi_1) - \cos \varphi_1 \sin \delta_{b1} \cos (q_1 - \psi_1); \\ c_2^{(1)} = & -\cos \varphi_1 \sin (q_1 - \psi_1) - \sin \varphi_1 \sin \delta_{b1} \cos (q_1 - \psi_1); \\ c_3^{(1)} = & \cos \delta_{b1} \cos (q_1 - \psi_1), \end{aligned}$$

where  $\operatorname{tg} \psi_1 = \varphi_1 \frac{\cos \gamma_1'}{\sin (\delta_{b_1} + \gamma_1')}$

Equations for crown surface  $\Sigma_{p_1}$  and of the projections of the vector of the normal to this same surface in the system  $x_0, y_0, z_0$  are written:

$$\begin{aligned} x_0^{(p_1)} &= (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) \cos \gamma_1 + u_1 \sin \alpha_1 \sin \gamma_1 \cos (\theta_1 - q_1 + \psi_1) + \\ &\quad + b_1 \sin \gamma_1 \cos (q_1 - \psi_1) + |\Delta L_1| \sin \gamma_1; \\ y_0^{(p_1)} &= u_1 \sin \alpha_1 \sin (\theta_1 - q_1 + \psi_1) - b_1 \sin (q_1 - \psi_1); \\ z_0^{(p_1)} &= -(r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) \sin \gamma_1 + u_1 \sin \alpha_1 \cos \gamma_1 \cos (\theta_1 - q_1 + \psi_1) + \\ &\quad + b_1 \cos \gamma_1 \cos (q_1 - \psi_1) + |\Delta L_1| \cos \gamma_1; \\ &\quad - [ -u_1 + (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1 - |\Delta L_1| \operatorname{tg} \delta_{b_1}) \cos \alpha_1 ] \sin (\theta_1 - q_1 + \psi_1) + \\ &\quad + b_1 \sin \alpha_1 \sin (q_1 - \psi_1) + b_1 \cos \alpha_1 \sin \theta_1 \operatorname{tg} \gamma_1' = 0; \end{aligned} \quad (2.7)$$

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$$\begin{aligned} e_{x_0}^{(p_1)} &= \sin \alpha_1 \cos \gamma_1 + \cos \alpha_1 \sin \gamma_1 \cos (\theta_1 - q_1 + \psi_1); \\ e_{y_0}^{(p_1)} &= \cos \alpha_1 \sin (\theta_1 - q_1 + \psi_1); \\ e_{z_0}^{(p_1)} &= -\sin \alpha_1 \sin \gamma_1 + \cos \alpha_1 \cos \gamma_1 \cos (\theta_1 - q_1 + \psi_1). \end{aligned} \quad (2.8)$$

### 3. Selecting Parameters for Cutting Heads and Machine Adjustment

When parameters are being selected, as noted in [3], gear tooth surfaces must be instantaneously mated when they touch at the midpoint. This requires that both crown surfaces and pinion and gear tooth surfaces touch each other at midpoint  $M_1$  ( $i = 1, 2$ ) (cf. figures 1 and 2), which is the point of intersection of axes  $0_0 z_0$  and  $0_{ni} z_{ni}$ . Axis  $0_0 z_0$  coincides with the overall generatrix of normal cones of bevel gears and is their axis of rotation in relative motion.

The crown surfaces and the surfaces of the teeth to be cut can be brought to touch at the midpoint  $M_1$  ( $i = 1, 2$ ) by the appropriate setting of the machine's rolling chain. This requires that the gear ratio be calculated so that the instantaneous rotation axis in relative motion of the crown wheel and the wheels to be cut passes through midpoint  $M_1$ .



On the basis of this condition and referring to structures in figures 1 and 2, we obtain the following for the gear

(3.1)

for the pinion

$$i_{p,1} = \frac{\sin \delta_1}{\cos \gamma_1},$$

$$i_{p,1} = \frac{\sin (\delta_{b_1} + \gamma'_1)}{\cos \gamma'_1}. \quad (3.2)$$

Here angle  $\gamma'_1$  is calculated from the equation (cf. figure 1)

$$\operatorname{tg} \gamma'_1 = \frac{L \sin \gamma_1 + |\Delta L_1| \operatorname{tg} \delta_{b_1}}{L \cos \gamma_1 - |\Delta L_1|}. \quad (3.3)$$

In addition, if generating surfaces touch each other at point  $M_1$ , and the instantaneous rotation axis of rotation passes through  $M_1$ , the surfaces of the teeth will also touch each other at point  $M_1$ .

This requires that the radius-vector of the crown surfaces and the normal's unit vector at point  $M_1$  be equal, i.e.

$$\vec{r}_0^{(p_1)} = \vec{r}_0^{(p_1)}, \quad \vec{e}_0^{(p_1)} = \vec{e}_0^{(p_1)}. \quad (3.4)$$

On the basis of these equations and (2.3), (2.4), (2.7), and (2.8) for crown surfaces and unit vectors of normals in the  $x_0, y_0, z_0$  system, when  $\psi_1 = \psi_2 = 0$ , we obtain: /35

$$\begin{aligned} & (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) \cos \gamma_1 + u_1 \sin \alpha_1 \sin \gamma_1 \cos (\theta_1 - q_1) + \\ & + b_1 \sin \gamma_1 \cos q_1 + |\Delta L_1| \sin \gamma_1 = (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) \cos \gamma_2 - \\ & - u_2 \sin \alpha_2 \sin \gamma_2 \cos (\theta_2 - q_2) - b_2 \sin \gamma_2 \cos q_2; \\ & u_1 \sin \alpha_1 \sin (\theta_1 - q_1) - b_1 \sin q_1 = u_2 \sin \alpha_2 \sin (\theta_2 - q_2) - b_2 \sin q_2, \\ & - (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) \sin \gamma_1 + u_1 \sin \alpha_1 \cos \gamma_1 \cos (\theta_1 - q_1) + \\ & + b_1 (\cos \gamma_1 \cos q_1 + |\Delta L_1| \cos \gamma_1) = (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) \sin \gamma_2 + \\ & + u_2 \sin \alpha_2 \cos \gamma_2 \cos (\theta_2 - q_2) + b_2 \cos \gamma_2 \cos q_2; \end{aligned} \quad (3.5)$$

$$\sin \alpha_1 \cos \gamma_1 + \cos \alpha_1 \sin \gamma_1 \cos (\theta_1 - q_1) = \sin \alpha_2 \cos \gamma_2 - \cos \alpha_2 \sin \gamma_2 \cos (\theta_2 - q_2); \quad (3.6)$$

$$\cos \alpha_1 \sin (\theta_1 - q_1) = \cos \alpha_2 \sin (\theta_2 - q_2); \quad (3.6)$$

$$-\sin \alpha_1 \sin \gamma_1 + \cos \alpha_1 \cos \gamma_1 \cos (\theta_1 - q_1) = \sin \alpha_2 \sin \gamma_2 + \cos \alpha_2 \cos \gamma_2 \cos (\theta_2 - q_2).$$

The constructions in figures 1 and 2 show that parameters for setting up the cutting head are related to equations

$$\operatorname{ctg} q_1 = \frac{L \cos \gamma_1 - |\Delta L_1| - r_1 \sin \beta_1}{r_1 \cos \beta_1} \quad (3.7)$$

$$\operatorname{ctg} q_2 = \frac{L \cos \gamma_2 - r_2 \sin \beta_2}{r_2 \cos \beta_2}; \quad (3.8)$$

$$b_i = \frac{r_i \cos \beta_i}{\sin q_i} \quad (3.9)$$

For midpoint  $M_i$   $u_i = r_i / \sin \alpha_i$ ,  $v_i = 90^\circ - \beta_i + q_i$ . After substituting  $b_i$ ,  $u_i$ , and  $v_i$  in equations (3.5) we can be sure that  $\bar{r}_0^{(p_i)} = \bar{r}_0^{(p_i)}$ . Substituting  $v_i$  into equations (3.6), we obtain the equation

$$\begin{aligned} \sin \alpha_2 \cos \gamma_2 - \cos \alpha_2 \sin \gamma_2 \sin \beta_2 &= \sin \alpha_1 \cos \gamma_1 + \cos \alpha_1 \sin \gamma_1 \sin \beta_1, \\ \cos \alpha_2 \cos \beta_2 &= \cos \alpha_1 \cos \beta_1, \\ \sin \alpha_2 \sin \gamma_2 + \cos \alpha_2 \cos \gamma_2 \sin \beta_2 &= -\sin \alpha_1 \sin \gamma_1 + \cos \alpha_1 \cos \gamma_1 \sin \beta_1 \end{aligned} \quad (3.10)$$

System (3.10) contains four unknowns:  $\alpha_1$ ,  $\alpha_2$ ,  $\beta_1$ , and  $\beta_2$ ; of the three equations in this system, only two are independent.

The missing equations for calculating the unknowns are derived on the basis of the fact that the values for angles  $\alpha_1$ , and  $\alpha_2$  are calculated with a well-known approximated form used in tooth-cutting practice:

$$\alpha_i = \alpha \pm \frac{1}{2} \sin \beta (\operatorname{tg} \gamma_2 + \operatorname{tg} \gamma_1) \frac{180^\circ}{\pi}, \quad (3.11)$$

where  $\alpha$  is the nominal cutter profile angle;  $\beta$  is the nominal tooth inclination.

Here and henceforth, a superscript will indicate gear cutting ( $i = 2$ ), a subscript -- pinion cutting ( $i = 1$ ).

After  $\alpha_1$  is calculated, angles  $\beta_1$  and  $\beta_2$  must be found from equations (3.10). After transformation, we obtain

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$$\sin \beta_1 = \frac{\sin \alpha_2 - \sin \alpha_1 \cos (\gamma_2 + \gamma_1)}{\cos \alpha_1 \sin (\gamma_2 + \gamma_1)}, \quad (3.12)$$

$$\sin \beta_2 = \frac{\sin \alpha_2 \cos (\gamma_2 + \gamma_1) - \sin \alpha_1}{\cos \alpha_2 \sin (\gamma_2 + \gamma_1)}. \quad (3.13)$$

The forming radii are determined from the equation (cf. figures 3 and 4):

$$r_i = r_n \mp \frac{w}{2} \mp L \sin \gamma_i \operatorname{tg} \alpha_i, \quad (3.14)$$

where  $r_n$  is the nominal cutting head radius;  $w$  is the cutter set.

#### 4. Determining Operating Line and Instantaneous Gear Ratio

Solving this problem requires finding equations for the surfaces of gear and pinion teeth and projections of the unit vector for the normals to the surfaces in the fixed system  $x_0, y_0, z_0$ .

This requires that we use the derivative of the matrices  $M_{0bi}, M_{bii}^*$ , which express the transition from  $x_i, y_i, z_i$  to  $x_0, y_0, z_0$  (cf. figures 3 and 4):

$$M_{0bi} \dot{M}_{bii} = \begin{vmatrix} \cos \delta_i \cos \dot{\varphi}_i \mp \cos \delta_i \sin \dot{\varphi}_i & \mp \sin \delta_i & 0 \\ \pm \sin \dot{\varphi}_i & \cos \dot{\varphi}_i & 0 \\ \pm \sin \delta_i \cos \dot{\varphi}_i - \sin \delta_i \sin \dot{\varphi}_i & \cos \delta_i & 0 \\ 0 & 0 & 1 \end{vmatrix} \quad (4.1)$$

Using equations (4.1), (2.1), (2.2), (2.5), and (2.6), after transformation we obtain:

$$\begin{aligned}
x_0^{(1)} &= (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) A_1^{(1)} + u_1 \sin \alpha_1 \sin \vartheta_1 B_1^{(1)} + \\
&\quad + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1) C_1^{(1)} + |\Delta L_1| D_1^{(1)}; \\
y_0^{(1)} &= (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) A_2^{(1)} + u_1 \sin \alpha_1 \sin \vartheta_1 B_2^{(1)} + \\
&\quad + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1) C_2^{(1)} + |\Delta L_1| D_2^{(1)}; \\
z_0^{(1)} &= (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) A_3^{(1)} + u_1 \sin \alpha_1 \sin \vartheta_1 B_3^{(1)} + \\
&\quad + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1) C_3^{(1)} + |\Delta L_1| D_3^{(1)}; \\
&\quad - [u_1 - (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1 - |\Delta L_1| \operatorname{tg} \delta_{b_1}) \cos \alpha_1] \sin (\vartheta_1 - q_1 + \psi_1) + \\
&\quad + b_1 [\cos \alpha_1 \operatorname{tg} \gamma_1 \sin \vartheta_1 + \sin \alpha_1 \sin (q_1 - \psi_1)] = 0;
\end{aligned} \tag{4.2}$$

$$\begin{aligned}
x_0^{(2)} &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) A_1^{(2)} + u_2 \sin \alpha_2 \sin \vartheta_2 B_1^{(2)} + \\
&\quad + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) C_1^{(2)}; \\
y_0^{(2)} &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) A_2^{(2)} + u_2 \sin \alpha_2 \sin \vartheta_2 B_2^{(2)} + \\
&\quad + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) C_2^{(2)}; \\
z_0^{(2)} &= (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) A_3^{(2)} + u_2 \sin \alpha_2 \sin \vartheta_2 B_3^{(2)} + \\
&\quad + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) C_3^{(2)};
\end{aligned} \tag{4.3}$$

$$\begin{aligned}
& [u_2 - (r_2 \operatorname{ctg} \alpha_2 + L \sin \gamma_2) \cos \alpha_2] \sin (\vartheta_2 - q_2 + \psi_2) + \\
& + b_2 [\cos \alpha_2 \operatorname{tg} \gamma_2 \sin \vartheta_2 - \sin \alpha_2 \sin (q_2 - \psi_2)] = 0; \\
e_{x_i}^{(i)} &= \sin \alpha_i A_1^{(i)} + \cos \alpha_i \sin \vartheta_i B_1^{(i)} + \cos \alpha_i \cos \vartheta_i C_1^{(i)}; \\
e_{y_i}^{(i)} &= \sin \alpha_i A_2^{(i)} + \cos \alpha_i \sin \vartheta_i B_2^{(i)} + \cos \alpha_i \cos \vartheta_i C_2^{(i)}; \\
e_{z_i}^{(i)} &= \sin \alpha_i A_3^{(i)} + \cos \alpha_i \sin \vartheta_i B_3^{(i)} + \cos \alpha_i \cos \vartheta_i C_3^{(i)}.
\end{aligned} \tag{4.4}$$

In equations (4.2), (4.3), and (4.4):

$$\begin{aligned}
A_1^{(i)} &= \cos \delta_i \cos (\varphi_i' - \varphi_i) \cos \delta_{b_i} + \sin \delta_i \sin \delta_{b_i}; \\
A_2^{(i)} &= \pm \sin (\varphi_i' - \varphi_i) \cos \delta_{b_i}; \\
A_3^{(i)} &= \pm \sin \delta_i \cos (\varphi_i' - \varphi_i) \cos \delta_{b_i} + \cos \delta_i \sin \delta_{b_i}; \\
B_1^{(i)} &= \pm \cos \delta_i \cos (\varphi_i' - \varphi_i) \sin \delta_{b_i} \sin (q_i - \psi_i) \mp \\
&\quad \mp \cos \delta_i \sin (\varphi_i' - \varphi_i) \cos (q_i - \psi_i) \mp \sin \delta_i \cos \delta_{b_i} \sin (q_i - \psi_i); \\
B_2^{(i)} &= \sin (\varphi_i' - \varphi_i) \sin \delta_{b_i} \sin (q_i - \psi_i) + \cos (\varphi_i' - \varphi_i) \cos (q_i - \psi_i); \\
B_3^{(i)} &= \sin \delta_i \cos (\varphi_i' - \varphi_i) \sin \delta_{b_i} \sin (q_i - \psi_i) - \\
&\quad - \sin \delta_i \sin (\varphi_i' - \varphi_i) \cos (q_i - \psi_i) + \cos \delta_i \cos \delta_{b_i} \sin (q_i - \psi_i); \\
C_1^{(i)} &= \pm \cos \delta_i \cos (\varphi_i' - \varphi_i) \sin \delta_{b_i} \cos (q_i - \psi_i) \pm \\
&\quad \pm \cos \delta_i \sin (\varphi_i' - \varphi_i) \sin (q_i - \psi_i) \mp \sin \delta_i \cos \delta_{b_i} \cos (q_i - \psi_i);
\end{aligned}$$

$$C_2^{(i)} = \sin(\varphi_i' - \varphi_i) \sin \delta_{b_i} \cos(q_i - \psi_i) - \cos(\varphi_i' - \varphi_i) \sin(q_i - \psi_i);$$

$$C_3^{(i)} = \sin \delta_i \cos(\varphi_i' - \varphi_i) \sin \delta_{b_i} \cos(q_i - \psi_i) + \\ + \sin \delta_i \sin(\varphi_i' - \varphi_i) \sin(q_i - \psi_i) + \cos \delta_i \cos \delta_{b_i} \cos(q_i - \psi_i);$$

$$D_1^{(i)} = -\cos \delta_i \cos(\varphi_i' - \varphi_i) \sin \delta_{b_i} + \sin \delta_i \cos \delta_{b_i};$$

$$D_2^{(i)} = \sin(\varphi_i' - \varphi_i) \sin \delta_{b_i};$$

$$D_3^{(i)} = \sin \delta_i \cos(\varphi_i' - \varphi_i) \sin \delta_{b_i} + \cos \delta_i \cos \delta_{b_i}.$$

Here and in equation (4.1), the superscript indicates cutting a gear ( $i = 2$ ), the subscript -- cutting a pinion ( $i = 1$ ).

We know from analytical geometry [4] that coefficients for the transformation equations for rectangular coordinate systems are related by the functions:

$$\begin{aligned} [A_1^{(i)}]^2 + [A_2^{(i)}]^2 + [A_3^{(i)}]^2 &= 1; \\ [B_1^{(i)}]^2 + [B_2^{(i)}]^2 + [B_3^{(i)}]^2 &= 1; \\ [C_1^{(i)}]^2 + [C_2^{(i)}]^2 + [C_3^{(i)}]^2 &= 1; \end{aligned} \quad (4.5)$$

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$$\begin{aligned} A_1^{(i)} B_1^{(i)} + A_2^{(i)} B_2^{(i)} + A_3^{(i)} B_3^{(i)} &= 0; \\ B_1^{(i)} C_1^{(i)} + B_2^{(i)} C_2^{(i)} + B_3^{(i)} C_3^{(i)} &= 0; \\ C_1^{(i)} A_1^{(i)} + C_2^{(i)} A_2^{(i)} + C_3^{(i)} A_3^{(i)} &= 0. \end{aligned} \quad (4.6)$$

In addition, it is easy to be sure that  $A_j^{(1)}$ ,  $B_j^{(1)}$ ,  $C_j^{(1)}$  and  $D_j^{(1)}$  ( $j = 1, 2, 3$ ) are related by equations:

$$\begin{aligned} A_1^{(1)} D_1^{(1)} + A_2^{(1)} D_2^{(1)} + A_3^{(1)} D_3^{(1)} &= 0; \\ B_1^{(1)} D_1^{(1)} + B_2^{(1)} D_2^{(1)} + B_3^{(1)} D_3^{(1)} &= 0; \\ C_1^{(1)} D_1^{(1)} + C_2^{(1)} D_2^{(1)} + C_3^{(1)} D_3^{(1)} &= 0; \\ [D_1^{(1)}]^2 + [D_2^{(1)}]^2 + [D_3^{(1)}]^2 &= 1. \end{aligned} \quad (4.7)$$

To calculate the contact point of the gear and pinion teeth, we have to use the following system of equations:

$$\begin{aligned} x_0^{(1)} &= x_0^{(2)}; \quad e_{x_0}^{(1)} = e_{x_0}^{(2)}; \\ y_0^{(1)} &= y_0^{(2)}; \quad e_{y_0}^{(1)} = e_{y_0}^{(2)}; \\ z_0^{(1)} &= z_0^{(2)}; \quad e_{z_0}^{(1)} = e_{z_0}^{(2)}; \end{aligned}$$

$$\begin{aligned}
& [-u_1 + (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1 - |\Delta L_1| \operatorname{tg} \delta_{b_1}) \cos \alpha_1] \sin (\vartheta_1 - q_1 + \psi_1) + \\
& + b_1 [\cos \alpha_1 \operatorname{tg} \gamma_1' \sin \vartheta_1 + \sin \alpha_1 \sin (q_1 - \psi_1)] = 0; \\
& [u_2 - (r_2 \operatorname{ctg} \alpha_2 + L \sin \gamma_2) \cos \alpha_2] \sin (\vartheta_2 - q_2 + \psi_2) + \\
& + b_2 [\cos \alpha_2 \operatorname{tg} \gamma_2 \sin \vartheta_2 - \sin \alpha_2 \sin (q_2 - \psi_2)] = 0.
\end{aligned} \tag{4.8}$$

From equations (4.8), it is obvious that

$$[x_0^{(1)}]^2 + [y_0^{(1)}]^2 + [z_0^{(1)}]^2 = [x_0^{(2)}]^2 + [y_0^{(2)}]^2 + [z_0^{(2)}]^2 \tag{4.9}$$

$$e_{x_0}^{(1)} x_0^{(1)} + e_{y_0}^{(1)} y_0^{(1)} + e_{z_0}^{(1)} z_0^{(1)} = e_{x_0}^{(2)} x_0^{(2)} + e_{y_0}^{(2)} y_0^{(2)} + e_{z_0}^{(2)} z_0^{(2)}. \tag{4.10}$$

Substituting equations (4.2) and (4.3) into (4.9); (4.2), (4.3), and (4.4) into (4.10), and taking into account functions (4.5), (4.6), and (4.7), after transformation we obtain:

$$\begin{aligned}
& (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1)^2 + (u_1 \sin \alpha_1 \sin \vartheta_1)^2 + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1)^2 + \\
& + |\Delta L_1|^2 + 2 |\Delta L_1| [u_1 \sin \alpha_1 \cos (\vartheta_1 - q_1 + \psi_1) + b_1 \cos (q_1 - \psi_1)] = \\
& = (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2)^2 + (u_2 \sin \alpha_2 \sin \vartheta_2)^2 + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2)^2.
\end{aligned} \tag{4.11}$$

$$\begin{aligned}
& \sin \alpha_1 (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1) + b_1 \cos \alpha_1 \cos \vartheta_1 + |\Delta L_1| \cos \alpha_1 \cos (\vartheta_1 - q_1 + \psi_1) = \\
& = \sin \alpha_2 (r_2 \operatorname{ctg} \alpha_2 + L \sin \gamma_2) + b_2 \cos \alpha_2 \cos \vartheta_2.
\end{aligned} \tag{4.12}$$

To determine parameters  $u_1, \vartheta_1, \psi_1, \phi'_1, u_2, \vartheta_2, \psi_2$ , and  $\phi'_2$ , using equations (4.8), (4.11), and (4.12) we obtain the following system of equations:

$$\begin{aligned}
& [-u_1 + (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1) \cos \alpha_1] \sin (\vartheta_1 - q_1 + \psi_1) + b_1 \cos \alpha_1 \operatorname{tg} \gamma_1' \sin \vartheta_1 + \\
& + b_1 \sin \alpha_1 \sin (q_1 - \psi_1) = 0;
\end{aligned} \tag{a}$$

$$\begin{aligned}
& \sin \alpha_1 (r_1 \operatorname{ctg} \alpha_1 - L \sin \gamma_1) + b_1 \cos \alpha_1 \cos \vartheta_1 + |\Delta L_1| \cos \alpha_1 \cos (\vartheta_1 - q_1 + \psi_1) - \\
& - \sin \alpha_2 (r_2 \operatorname{ctg} \alpha_2 + L \sin \gamma_2) - b_2 \cos \alpha_2 \cos \vartheta_2 = 0;
\end{aligned} \tag{b}$$

$$\begin{aligned}
& (r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1)^2 + (u_1 \sin \alpha_1 \sin \vartheta_1)^2 + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1)^2 + \\
& + (\Delta L_1)^2 + 2 |\Delta L_1| [u_1 \sin \alpha_1 \cos (\vartheta_1 - q_1 + \psi_1) + b_1 \cos (q_1 - \psi_1)] - (r_2 \operatorname{ctg} \alpha_2 - \\
& - u_2 \cos \alpha_2 + L \sin \gamma_2)^2 - (u_2 \sin \alpha_2 \sin \vartheta_2)^2 - (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2)^2 = 0;
\end{aligned} \tag{c}$$

$$[u_2 - (r_2 \operatorname{ctg} \alpha_2 + L \sin \gamma_2) \cos \alpha_2] \sin (\vartheta_2 - q_2 + \psi_2) + b_2 \cos \alpha_2 \operatorname{tg} \gamma_2 \sin \vartheta_2 - b_2 \sin \alpha_2 \sin (q_2 - \psi_2) = 0; \quad (d)$$

$$\sin \alpha_1 A_1^{(1)} + \cos \alpha_1 \sin \vartheta_1 B_1^{(1)} + \cos \alpha_1 \cos \vartheta_1 C_1^{(1)} - \sin \alpha_2 A_1^{(2)} - \cos \alpha_2 \sin \vartheta_2 B_1^{(2)} - \cos \alpha_2 \cos \vartheta_2 C_1^{(2)} = 0; \quad (e)$$

$$\sin \alpha_1 A_3^{(1)} + \cos \alpha_1 \sin \vartheta_1 B_3^{(1)} + \cos \alpha_1 \cos \vartheta_1 C_3^{(1)} - \sin \alpha_2 A_3^{(2)} - \cos \alpha_2 \sin \vartheta_2 B_3^{(2)} - \cos \alpha_2 \cos \vartheta_2 C_3^{(2)} = 0; \quad (f)$$

$$(r_1 \operatorname{ctg} \alpha_1 - u_1 \cos \alpha_1 - L \sin \gamma_1) A_1^{(1)} + u_1 \sin \alpha_1 \sin \vartheta_1 B_1^{(1)} + (u_1 \sin \alpha_1 \cos \vartheta_1 + b_1) + |\Delta L_1| D_1^{(1)} = (r_2 \operatorname{ctg} \alpha_2 - u_2 \cos \alpha_2 + L \sin \gamma_2) A_1^{(2)} + u_2 \sin \alpha_2 \sin \vartheta_2 B_1^{(2)} + (u_2 \sin \alpha_2 \cos \vartheta_2 + b_2) C_1^{(2)}. \quad (g) \quad (4.13)$$

The system of transcendental equations (4.13) is solved by sequential approximation.

In solving system (4.13),  $\psi_1$  is considered fixed. Then the system has seven unknown equations, whose solution results in the calculating of the seven desired parameters  $u_1$ ,  $\vartheta_1$ ,  $\phi'_1$ ,  $u_2$ ,  $\vartheta_2$ ,  $\psi_2$ , and  $\phi'_2$ .

Substituting the resulting values into equations (2.1) and (2.5), we find the coordinates of points on the operating line on the surfaces of the teeth. Coordinates  $x_i$ ,  $y_i$ ,  $z_i$ , found for various  $\psi_1$  values, define the operating line.

Substituting values for  $u_1$ ,  $\vartheta_1$ ,  $\psi_1$ ,  $\phi'_1$ ,  $u_2$ ,  $\vartheta_2$ ,  $\psi_2$ , and  $\phi'_2$  into equations (4.2), (4.3), and (4.4), we find the coordinates of the point on the dedendum line of contact and the projection of the unit vector for the normal at this point.

Let us introduce an equation for finding the instantaneous gear ratio for gears.

In fixed system  $x_0$ ,  $y_0$ ,  $z_0$ , the equation for the normal to tooth surface contact point  $M_0^K$  is expressed as (cf. figure 5):

$$\frac{X_0 - x_0^K}{e_{x_0}^K} = \frac{Y_0 - y_0^K}{e_{y_0}^K} = \frac{Z_0 - z_0^K}{e_{z_0}^K}, \quad (4.14)$$

where  $X_0, Y_0, Z_0$  are the coordinates of the current normal point;  $x_0^K, y_0^K, z_0^K$  are the coordinates of point  $M_0^K$  of contact in system  $x_0, y_0, z_0$ , determined with equations (4.2) and (4.3);  $e_{x_0}^K, e_{y_0}^K, e_{z_0}^K$  are projections of the unit vector of the normal at the point of contact in this system, determined from equations (4.4).

At point  $N_K$ , where the normal intersects the plane of gear axes,  $Y_0 = 0$ . After substituting  $Y_0 = 0$  into equation (4.14), we obtain

$$\begin{aligned} X_0 &= x_0^K - \frac{e_{x_0}^K}{e_{y_0}^K} y_0^K, \\ Z_0 &= z_0^K - \frac{e_{z_0}^K}{e_{y_0}^K} y_0^K. \end{aligned} \quad (4.15)$$

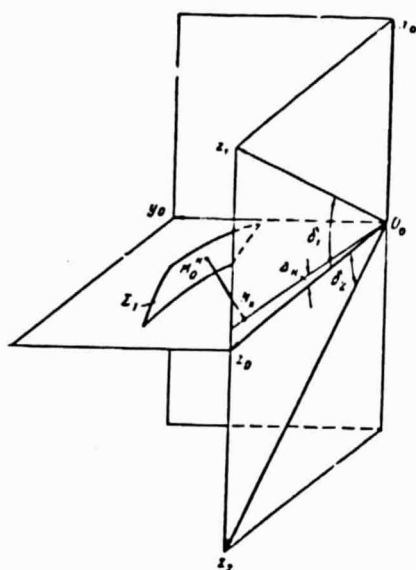


Figure 5. For solving the equation to determine instantaneous gear ratio.

Angle  $\Delta_K$  between axis  $z_0$  and instantaneous axis  $O_0N_K$  will be found with the equation

$$\operatorname{tg} \Delta_K = \frac{X_0}{Z_0} = \frac{x_0^K e_{y_0}^K - y_0^K e_{x_0}^K}{z_0^K e_{y_0}^K - y_0^K e_{z_0}^K}. \quad (4.16)$$



The instantaneous gear ratio for gears may be found from the equation (cf. figure 5):

$$i_{12} = \frac{\sin(\delta_2 + \Delta\alpha)}{\sin(\delta_2 - \Delta\alpha)} \quad (4.17)$$

### Example of Calculation

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Let us consider the case of cutting teeth on a pinion and gear with a gear ratio  $i_{12} = 1$ . The teeth on the gear are directed to the right; those on the pinion -- to the left. The number of teeth is  $z_1 = z_2 = 20$ . The face modulus  $m_g = 10$  mm, tooth inclination  $\beta = 35^\circ$ , meshing angle  $\alpha = 20^\circ$ , toothing width  $B = 40$  mm. Nominal cutting head radius  $r_u = 152.4$  mm, cutter set  $W = 1.524$  mm. Tooth cutting method: one-sided. Axial displacement  $\Delta S_1 = -10$  mm.

Using ENIMS [expansion unknown] system geometric calculation [3] and calculating equations for setting up the machine given in point\3, we will find the parameters for meshing of gears, cutting heads, and setting up the machine.  $\Delta L_1$  is found with the equation [3]  $\Delta L_1 = -\Delta S_1 \cos \delta_{b1}$ .

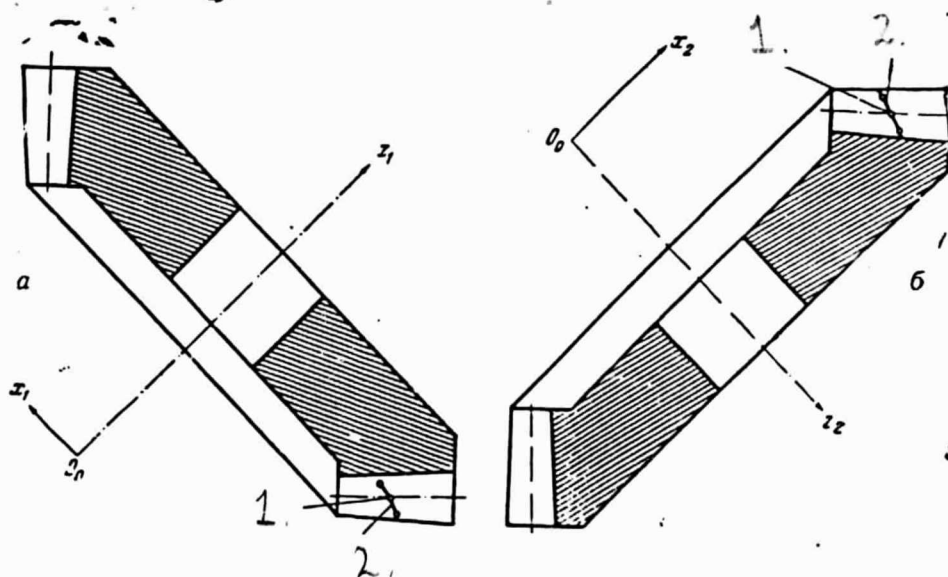


Figure 6. Projections of the operating line. 1 - Midpoint; 2 - Operating line.

Let us introduce values for solving system (4.13):

	<u>Gear</u>	<u>Wheel</u>
Average generatrix, $L$	121.4214	121.4214
Initial cone angle, $\delta_i$	45°	45°
Angle of dedendum part of tooth, $\tau_i$	4.125308°	4.125308°
Internal bevel angle, $\delta_{bi}$	40.87469°	40.87469°
Cutter angle, $\alpha_i$	17.62972°	22.37028°
Angle of spiral in locating plane, $\beta_i$	36.24563°	33.78168°
Forming radius, $r_i$	155.9378	148.0431
Angular adjustment, $q_i$	80.36620°	72.50272°
Radial adjustment, $b_i$	127,5611°	129.0173°
Axial displacement, $\Delta S_i$	10	0
Rolling chain gear ratio, $i_{pii}$	0.7561548	0.7089436

The results of calculation using equations in system /102 (4.13) and the coordinates of points on the operating line and of the instantaneous gear ratio for gears found according to equation (2.1), (2.5), (4.17), are given below:

	<u>Current values</u>		
Rotation angle of crown wheel, $p_i, \psi_i$	-5°	0°	5°
Parameters for crown surface $\Sigma_{pi}$ :			
$v_1$	133.57°	134.12°	135.42°
$u_1$	520.64	514.88	509.48
Parameters for crown surface $\Sigma_{p2}$ :			
$v_2$	127.87°	128.72°	130.35°
$u_2$	394.42	388.95	383.47
Rotation angle of crown wheel $p_2, \psi_2$	-5.28°	0°	5.47°
Pinion rotation angle, $\phi'_1$	-7.65°	0°	7.82°
Gear rotation angle $\phi'_2$	7.25°	0°	7.16°

Coordinates of the point on the  
meshing line

$x_0^{(i)}$	-5.2	0	5.0
$y_0^{(i)}$	-11.2	0	11.9
$z_0^{(i)}$	123.5	121.4	116.6

Coordinates of the point of contact  
on the pinion tooth surface

$x_1$	-91.7	-85.9	-79.8
$y_1$	1.0	0.00	1.1
$z_1$	83.65	85.9	86.0

Coordinates of the point of contact  
on the gear tooth surface

$x_2$	84.4	85.9	86.8
$y_2$	-0.6	0	1.1
$z_2$	91.0	85.9	78.9
Gear ratio, $i_{12}$	1.002	1	0.966

These results were used to plot the projections of the operating line for pinion tooth surface on plane  $x_1O_1y_1$  (cf. figure 6, a) and of the operating line for gear tooth surface on plane  $x_2O_2y_2$  (cf. figure 6, b).

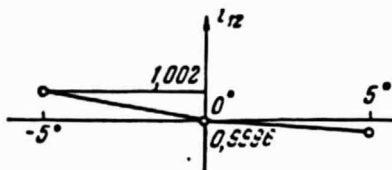


Figure 7. Graph of gear ratio function.

Figure 7 shows a graph of the change in gear ratio.

Calculations and constructions (cf. figure 6) show that, when axial displacement is introduced and the recommended method for calculating cutter head parameters and machine set-up is used, the operating lines pass through the designated midpoints on the surfaces of the teeth, and the diagonal nature of the operation line (bearing pattern) is already eliminated.

Therefore, we may draw the following conclusion. The diagonal nature of contact can be eliminated by changing displacement and gear ratio of the rolling chain. Displacement must be negative if the convex side of the gear tooth is being cut, i.e. the head should be shifted forward. Shift in this case amounts to about 10 mm, but it may be somewhat less. Optimum axial displacement should be selected on the basis of experimental calculations. In critical cases, it is advisable to program the equations given here to perform calculations on computers.

The gear ratio of the gears still remains variable. However, its deviation from nominal is less than when gears are cut without correcting machine adjustment.

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